

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013584**Date Inspected:** 27-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Bay 1: CB 15.

This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

This QA Inspector measured the root gap for the Floor beam web. The below mentioned welds were observed to be having the root gap more than 5mm:

- 1) CB202G-045-053/054 – 8mm
- 2) CB202G-045-133/134 – 6mm
- 3) CB202G-046-053/054 – 8mm
- 4) CB202G-046-133/134 – 6mm
- 5) CB202G-046-135/136 – 8mm
- 6) CB202G-047-111/112 – 8mm
- 7) CB202G-048-135/136 – 6mm
- 8) CB202G-048-085/086 – 6mm

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bay 8: CB17.

This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

This QA Inspector measured the root gap for the Floor beam web to be welded with Top Panel. The below mentioned welds were observed to be having the root gap more than 5mm:

- 1) CB202G-053-001/002 – 7mm
- 2) CB202G-053-003/004 – 5-6mm
- 3) CB202G-053-029/030 – 5mm
- 4) CB202G-054-001/002 – 12mm
- 5) CB202G-054-003/004 – 12mm
- 6) CB202G-055-001/002 – 10mm
- 7) CB202G-055-003/004 – 9mm
- 8) CB202G-055-005/006 – 7mm
- 9) CB202G-056-001/002 – 7mm
- 10) CB202G-056-003/004 – 9mm
- 11) CB202G-056-005/006 – 7mm
- 12) CB202G-056-009/010 – 6mm
- 13) CB202G-056-025/026 – 5mm
- 14) CB202G-056-039/040 – 9mm
- 15) CB202G-056-041/042 – 6mm

Outside Yard:

CB10, CB11, CB12, CB13, & CB16:

This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

CB14:

Flux Cored Arc Welding (FCAW) of weld joint CB202G-042 – 147/165 & CB202G-043-147/165. Welder is identified as 217805. ZPMC Quality Control (QC) personnel is identified as Chen Xi. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132.

FCAW of weld joint FB205-044-039/040. Welder is identified as 050977. ZPMC QC is identified as Chen Xi. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F.

Trial Assembly:

CB7:

During random inprocess inspection of this CB, this QA Inspector observed ZPMC personnel doing fit-up of CB7

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

with OBG SEG 7BE & 7BW. ZPMC QC personnel was identified as Guo Yuan Ting.

CB8:

During random inprocess inspection of this CB, this QA Inspector observed ZPMC personnel doing fit-up of CB8 with OBG SEG 7DE & 7DW. ZPMC QC personnel was identified as Guo Yuan Ting.

CB9:

This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
